

Work Order ID 63677

Page 1

Tuesday, November 09, 2010 3:47:21 PM

Item ID: D3535-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *10-11-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100 *100* 0.00

FLOW WATER JET

Waterjet

Memo

0.00

R310-11-12

FLOW CNC Waterjet

*304 .040*1-Cut as per Dwg D3535 Dwg Rev: *B* Prog Rev: *B* 2-

Deburr if necessary

*(B)*110 *110* 0.00

QC2- Inspect parts off machine FAI/FAIB

0.00

R310-11-12

QC

Memo

Quality Control

120 *120* 0.00

QC8- Inspect parts - second check

0.00

S 10/11/12

QC

Memo

Quality Control

(H3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Stop



Start Date: 11/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

=) 10

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/11/18

13 φ

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FP-18 0.00

Memo

0.00

13 BL 10-11-18.

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/18 JJ

MF
10-11-18

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Picklist Print

Tuesday, November 09, 2010 3:47:21 PM

Page 1

Work Order ID: 63677



Parent Item: D3535-13



Parent Item Name: Wearshoe

Start Date: 11/10/2010

Required Date: 11/24/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	165.0000	0.8505	5.371579	11.1	10-11-12	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	161	
115762	10.2	
115953	150.8	115953
MAT20	4	
113062	1.398	
115440	2.602	

(13)

W/O:		WORK ORDER CHANGES					
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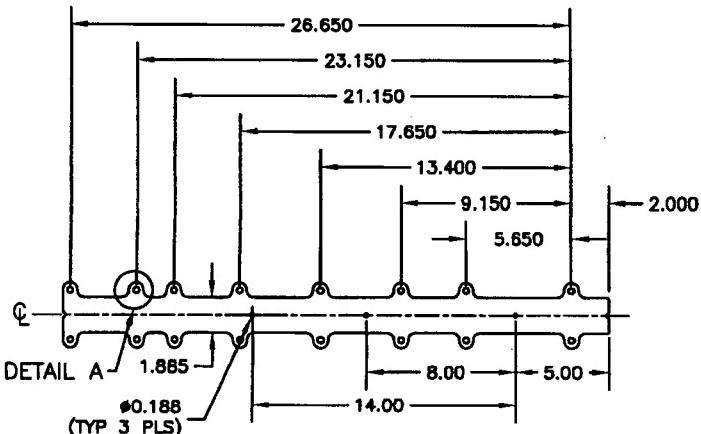
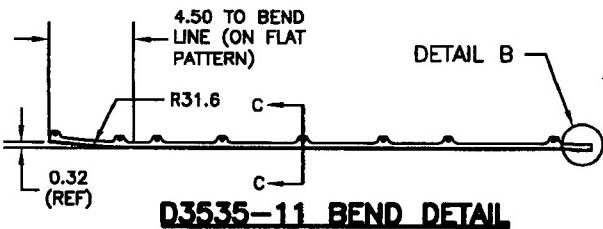
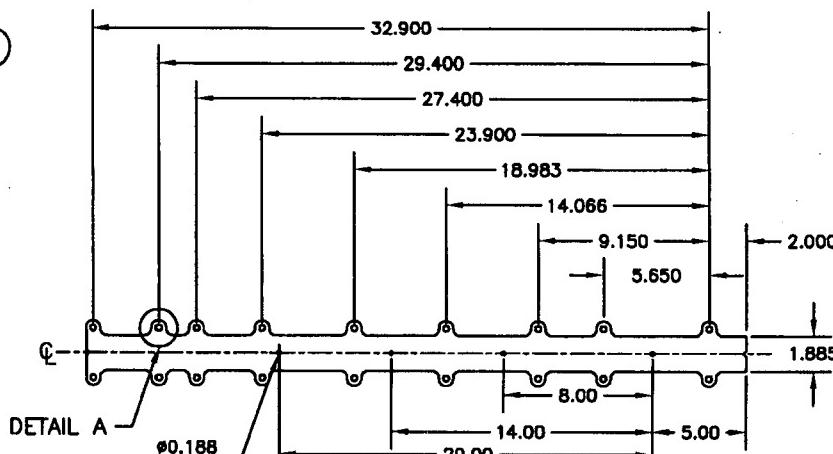
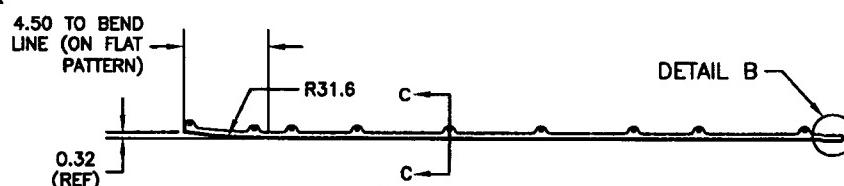
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DART

RELEASER

57-04-24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN C.B	DRAWN BY <i>MH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3535
DATE 07.04.17	DATE 07.04.17	TITLE WEARSHOE
A	06.10.25	NEW ISSUE
B	MOVE TAB OUTBOARD, ADD AMS SPEC	SCALE 1:10
		REV. B
		SHEET 1 OF 7

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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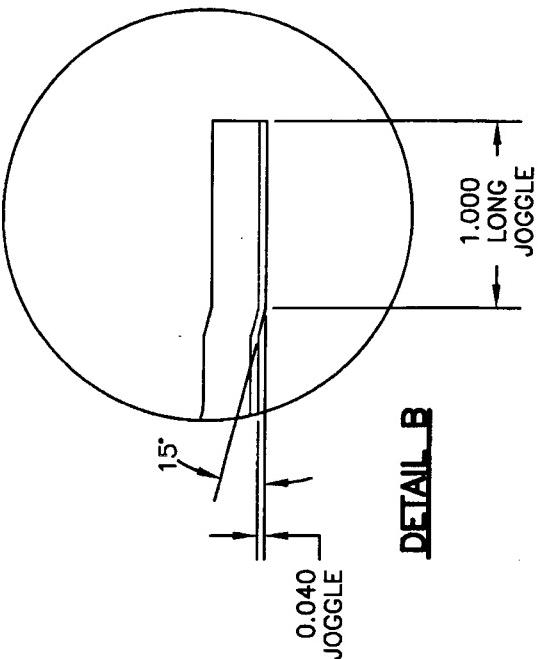
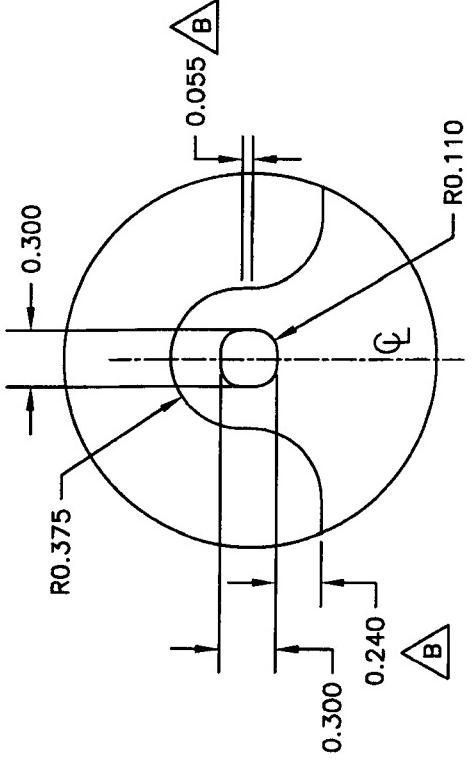
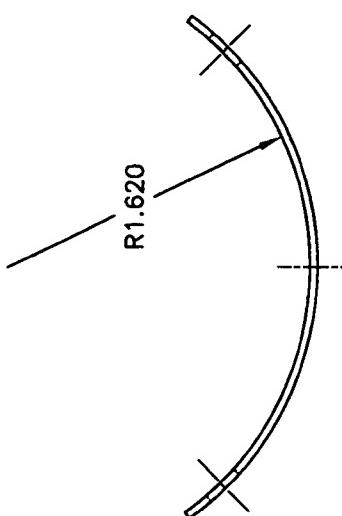
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NOTE: Date & initial all entries

DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:1	

RELEASED

07.04.24 *[initials]***DETAIL B****DETAIL A****SECTION C-C**

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DART AEROSPACE LTD		Work Order:	63677
Description: Wearshoe		Part Number:	D3535-13
Inspection Dwg: D3535	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	X		U HB02	
2.000	+/-0.010	2.000	X		V	
5.650	+/-0.010	5.650	X		T HB01	
9.150	+/-0.010	9.150	X		T	
14.066	+/-0.010	14.066	X		T	
18.983	+/-0.010	18.983	X		T	
23.900	+/-0.010	23.900	X		T	
27.400	+/-0.010	27.400	X		T	
29.400	+/-0.010	29.400	X		T	
32.900	+/-0.010	32.900	X		T	
Ø0.188	+0.005/-0.001	.193	X		V	
20.00	+/-0.030	20.00	X		T	
14.00	+/-0.030	14.00	X		T	
8.00	+/-0.030	8.00	X		T	
5.00	+/-0.030	5.00	X		T	
0.300	+/-0.010	.304	X		V	
0.300	+/-0.010	.304	X		V	
0.038	+/-0.010	.036	X		V	

Measured by:	HR	Audited by:	S	Prototype Approval:	N/A
Date:	10-11-12	Date:	10/14/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	S

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